

Flight test AUG 16

Work Order ID 72670



Thursday, August 04, 2011 2:43:46 PM

Item ID: D4418-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Lug

Start Date: 8/4/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-08-4

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4418	A

100

0.00



BAND SAW

0.00

Bandsaw

Memo

B.A 11/08/10

2

φ

Jeaspa Bandsaw

Cut Blank to 3.125"

110

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

B.A 11/08/11

2

φ

HAAS CNC vertical machine #1

1-Machine per folio FB0063

DWG REV: A

FOLIO REV: N/A

and 11/08/11

2- deburr rough edges

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

K.A. 11/08/11
any

2 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

29 11-8-12

2 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2 0 11/08/11

W/O:		WORK ORDER CHANGES					
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Page 3

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Required Date: 8/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

145



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

start Time: 10:50

0.00

Temp: 320°F

Finish Time: 11:20

2x0 M-11/08/15

M118439

Memo

MASK THREADED HOLE

146



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

2x0 M-11/08/15

180



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

2x0 M-11/08/15
11/5/16 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Reference:

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Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11-08-14
(2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, August 04, 2011 2:43:53 PM

Page 1

Work Order ID: 72670

Parent Item: D4418-1

Parent Item Name: Step Lug



Start Date: 8/4/2011

Required Date: 8/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-12 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B2.000X03.50 0		Purchased	No			100	f	12.7284	0.26	0.547368			



6061-T6 Bar 2.00 x 3.50



Location	Loc Qty	Loc Code
MAT003	12	
✓118182	12	
MAT009	0.7284	
112764	0.7284	

0.5473 +

B.A 11/08/10

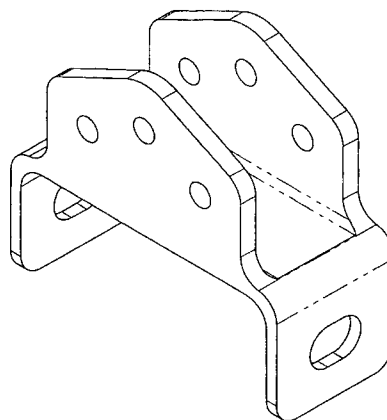
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D4418-1 STEP LUG

SHOP COPY.
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 72670

H11-08-4

RELEASED
2011-07-28
MA

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4418-1" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT: 0.20 lbs

A		NEW ISSUE		AJS	11.07.04
REV.	DESCRIPTION			BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			REV. A
DRAWN	AJS				
CHECKED	<i>GP</i>	DRAWING NO.			SHEET 1 OF 2
MFG. APPR.	<i>E</i>	D4418			
APPROVED	<i>MA</i>	TITLE			SCALE
DE APPR.	<i>#</i>	STEP LUG			
DATE	11.07.04	COPYRIGHT © 2011 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			NTS

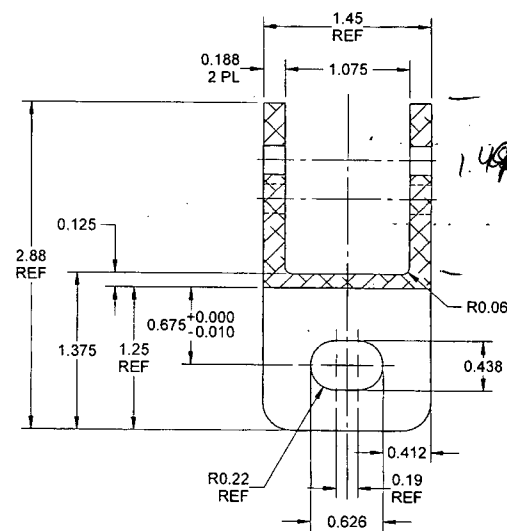
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RELEASED
2011-07-28

DESIGN	AJS	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4418 TITLE STEP LUG COPYRIGHT © 2011 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS RELEASED AND CONFIDENTIAL AND IS RETURNED TO THE SUPPLIER UPON REQUEST. IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	REV. A
DRAWN	AJS		SHEET 2 OF 2
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	11.07.04		

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DART AEROSPACE LTD		Work Order: 72670
Description: STEP LUG		Part Number: D4418-1
Inspection Dwg: D4418 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.30	$\pm .030$	3.295	—		Vern ML-7	
.45	$\pm .030$.447	—		"	
2.40	$\pm .030$	2.399	—		"	
Ø.257	$\pm .006$ $\pm .001$	Ø.258	—		"	
1.10	$\pm .030$	1.100	—		"	
.125	$\pm .010$.123	—		"	
3.045	$\pm .010$	3.042	—		"	
.700	$\pm .005$.700	—		"	
.780	$\pm .030$.781	—		"	
1.13	$\pm .030$	1.125	—		"	
.342	$\pm .005$.344	—		"	
2.88	$\pm .030$	2.873	—		"	
.125	$\pm .010$.126	—		"	
1.375	$\pm .010$	1.376	—		"	
.675	$\pm .000$ $\pm .010$.675	—		"	
.626	$\pm .010$.621	—		"	
.412	$\pm .010$.408	—		"	
.438	$\pm .010$.435	—		"	
R.06	$\pm .030$	R.060	—		R-G	
1.075	$\pm .010$	1.071	—		Vern ML-7	
1.45	$\pm .030$	1.448	—		"	
.188	$\pm .010$.189	—		"	

Measured by: <i>and</i>	Audited by: <i>RQ</i>	Preliminary Approval: <i>/</i>
Date: 11/08/12	Date: 11-8-12	Date: <i>/</i>

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15